

Work Order ID 60968



Tuesday, August 03, 2010 8:59:54 AM

Item ID: D4019-041

Accept



Setup Start



Stop



Revision ID:

Item Name: Light Lid Short Basket Assembly

Start Date: 8/4/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 8/10/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-8-03 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4019	C

100 Weld per dwg A/R Aluminum rod Batch: M12860 0.00
 Large Fab

Large Fab

Large Fab

Memo 0.00

1- Assemble ribs , weld as per dwg D4019 using DT9606B. When welding D4019-3, weld top and bottom then make a small hole in the weld to let air out. Then weld remaining sides of D4019-3 Rib. Let it cool down, then block holes with weld.

****DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME****

2- weld hinge, label plate and Mounting plates as per dwg D4019

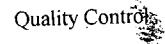
110



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC



Memo

0.00

BE 10/08/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60968



Tuesday, August 03, 2010 8:59:54 AM

Item ID: D4019-041

Accept



Setup Start



Revision ID:

Item Name: Light Lid Short Basket Assembly

Start Date: 8/4/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 8/10/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

S 10/08/10

130



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

= 10/08/10

X1 ✓

Memo

ENSURE TO RINSE CAREFULLY ACID AND ALODINE

140



Large Fab

Large Fab

Weld per dwg A/R Aluminum rod Batch: M12880 0.00

0.00

H 10-08-10

✓ ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60968

Tuesday, August 03, 2010 8:59:54 AM

Item ID: D4019-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Light Lid Short Basket Assembly



Cust Item ID:

Start Date: 8/4/2010 Start Qty: 1.00



Customer:

Required Date: 8/10/2010 Req'd Qty: 1.00



Reference:

Run Start



Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

**Sequence ID/
Work Center ID**

150



QC

Quality Control

**Operation
Description**

QC9- Inspect visual per QSI004- Fusion Welds

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M115291

0.00

=> JH

10/08/10

PD 10.08.10

1 9

Memo

- 1- touch up corner with alodine only
- 2- Plug holes prior to and mask sides of hinge prior to powdercoat

1ST COAT:

START TIME: 10:50AM

OVEN TEMPERATURE: 320°f

FINISH TIME: 11:20AM

***** 2nd coat if necessary*****

2ND COAT:

START TIME: 11:20AM

OVEN TEMPERATURE: _____

FINISH TIME: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60968

Tuesday, August 03, 2010 8:59:54 AM

Item ID: D4019-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Light Lid Short Basket Assembly



Cust Item ID:

Start Date: 8/4/2010 Start Qty: 1.00



Customer:

Required Date: 8/10/2010 Req'd Qty: 1.00

**Reference:**

Approvals: Process Plan: _____

Date: _____

QC: _____

Date: _____

Sequence ID/
Work Center ID

170



QC

Quality Control

Operation
Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



HandFinish

Hand Finishing

Assemble as per dwg

0.00

Memo

Install webbing as per dwg and label

190



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8/10/08/10

Memo

0.00



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60968



Tuesday, August 03, 2010 8:59:54 AM

Item ID: D4019-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Light Lid Short Basket Assembly

Start Date: 8/4/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 8/10/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center ID

200



Packaging

Packaging

Operation
Description

Identify as per dwg & Stock Location: G-A

w/o 60967

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

E/S 08/08/10 C

210



QC

Quality Control

Memo

QC21- Final Inspection - Work Order Release

0.00

0.00

10/08/11 JH

W 10.8.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, August 03, 2010 8:59:53 AM

Page 1

Work Order ID: 60968



Parent Item: D4019-041



Parent Item Name: Light Lid Short Basket Assembly

Start Date: 8/4/2010

Required Date: 8/10/2010

Comments:

IPP RevA: new issue DD 09.12.07 verified by:EC
per dwg revA 10.03.15 verified by:EC II
DD 10.04.20 verified by:EC

IPP Rev:B as
IPP Rev:C as per dwg revC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, August 03, 2010 8:59:53 AM

Work Order ID: 60968**Parent Item:** D4019-041**Parent Item Name:** Light Lid Short Basket Assembly**Start Date:** 8/4/2010**Required Date:** 8/10/2010**Start Qty:** 1.00**Required Qty:** 1.00

D4016-5

Manufactured No

100 Each 18.0000 3 3

Hinge Half, Light Lid

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ENG	2	
56075	2	
ST116	10	
58304	10	
WA	6	
58592	6	

100 Each 19.0000 4 4

ID 10.08.06

D2957

Manufactured No

100 Each 19.0000 4 4

Mounting Plate

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA	19	
57697	1	
58302	12	
58593	6	

100 Each 3.0000 1 1

ID 10.08.06

D4035-045

Manufactured No

100 Each 3.0000 1 1

Lid Rib Assembly, Fwd (Light)

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA	3	
58378	1	
59733	2	

ID 10.08.06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, August 03, 2010 8:59:53 AM

Work Order ID: 60968



Parent Item: D4019-041



Parent Item Name: Light Lid Short Basket Assembly

Start Date: 8/4/2010

Required Date: 8/10/2010

Start Qty: 1.00

Required Qty: 1.00

D4035-047



Manufactured No

100 Each 3.0000

1 1

ID 10.08.06

Lid Rib Assembly, Aft (Light)

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA	3	
----	---	--

58377

1

59734

2

Each 6.0000

1

1

1

1

1

1

1

8/30/08/10

D4029-043



Manufactured No

180 Each 6.0000

1

Webbing (Short Basket)

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

st503	6	
-------	---	--

56967

6

Each 13.0000

1

1

1

ID 10.08.06

D4056-1



Manufactured No

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA	13	
----	----	--

58308

9

58583

2

59750

2

1

1

Label Plate

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, August 03, 2010 8:59:53 AM

Work Order ID: 60968**Parent Item:** D4019-041**Parent Item Name:** Light Lid Short Basket Assembly**Start Date:** 8/4/2010**Required Date:** 8/10/2010**Start Qty:** 1.00**Required Qty:** 1.00

NAS1149DN416J

Purchased

No

180

Each

532.0000

30



30

Eg 510/08/10

Washer

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	ST	4	
	13910	4	
	ST275	132	
	114340	132	
	ST298	396	
	114348	52	
	114597	344	

Tuesday, August 03, 2010 8:59:53 AM

Shop Packet Print

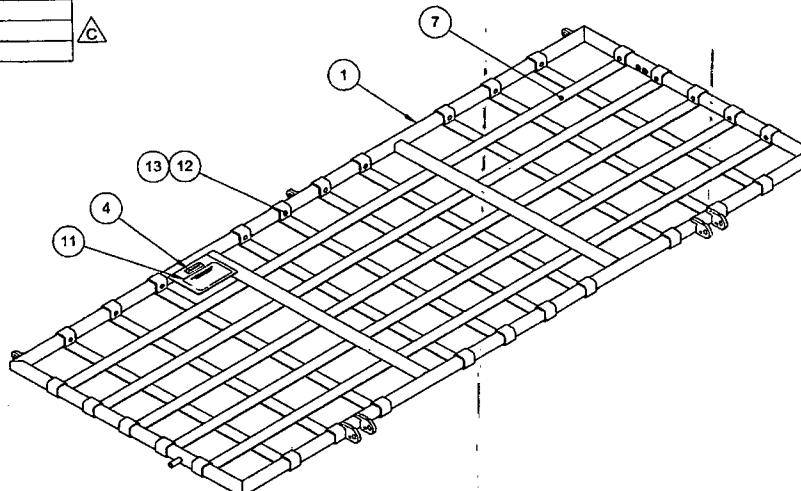
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -101	P/N	DESCRIPTION
	X		D4019-041	LIGHT LID SHORT BASKET ASSY
1	1	X	D4019-101	BASKET LID WELDMENT
2		2	D4019-1	RIB
3		2	D4019-3	RIB
4	1		D2728-1	DART LOGO LABEL
5		4	D2957	MOUNTING PLATE
6		3	D4016-5	HINGE HALF
7	1		D4029-043	WEBBING (SHORT BASKET)
8		1	D4035-045	LID RIB ASSY, FWD
9		1	D4035-047	LID RIB ASSY, AFT
10		1	D4056-1	LABEL PLATE, 350 LIGHT BASKET
11	1		D4086-243	PLACARD, MAX LOAD
12	30		MS20600AD4W3	BLIND RIVET
13	30		NAS1149DN416J	WASHER



D4019-041 LIGHT LID SHORT BASKET ASSY

RELEASED
R 2010-04-14
MM

C	MS20600AD4W3 WAS MS20600AD4W5: BOM & (B3-2)	JPH	10.04.06
B	BOM: INSERTED QTY 1 D2728-1 AS ITEM 4 & QTY 1 D4086-243 AS ITEM 13. ITEMS RENUMBERED AS REQD. DETAIL E ADDED (D4-2) & (D5-2). SECTION B-B REV'D (D6-3) DIM ADDED (B4-3). WELD SYMBOL REVISED (D5-3)	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PP	REV. C	
MFG. APPR.		DRAWING NO.	
APPROVED		D4019	SHEET 1 OF 4
DE APPR.		TITLE	SCALE
DATE	10.04.06	LIGHT LID SHORT BASKET NTS	

NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: NONE
 7) WEIGHT: 4.83 lbs

COPYRIGHT © 2010 BY DART AEROSPACE LTD
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
 NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISCLOSED TO ANY OTHER PERSON WITHOUT
 WRITTEN PERMISSION FROM DART AEROSPACE LTD.

8 1 7 6 5 4 3 2 1

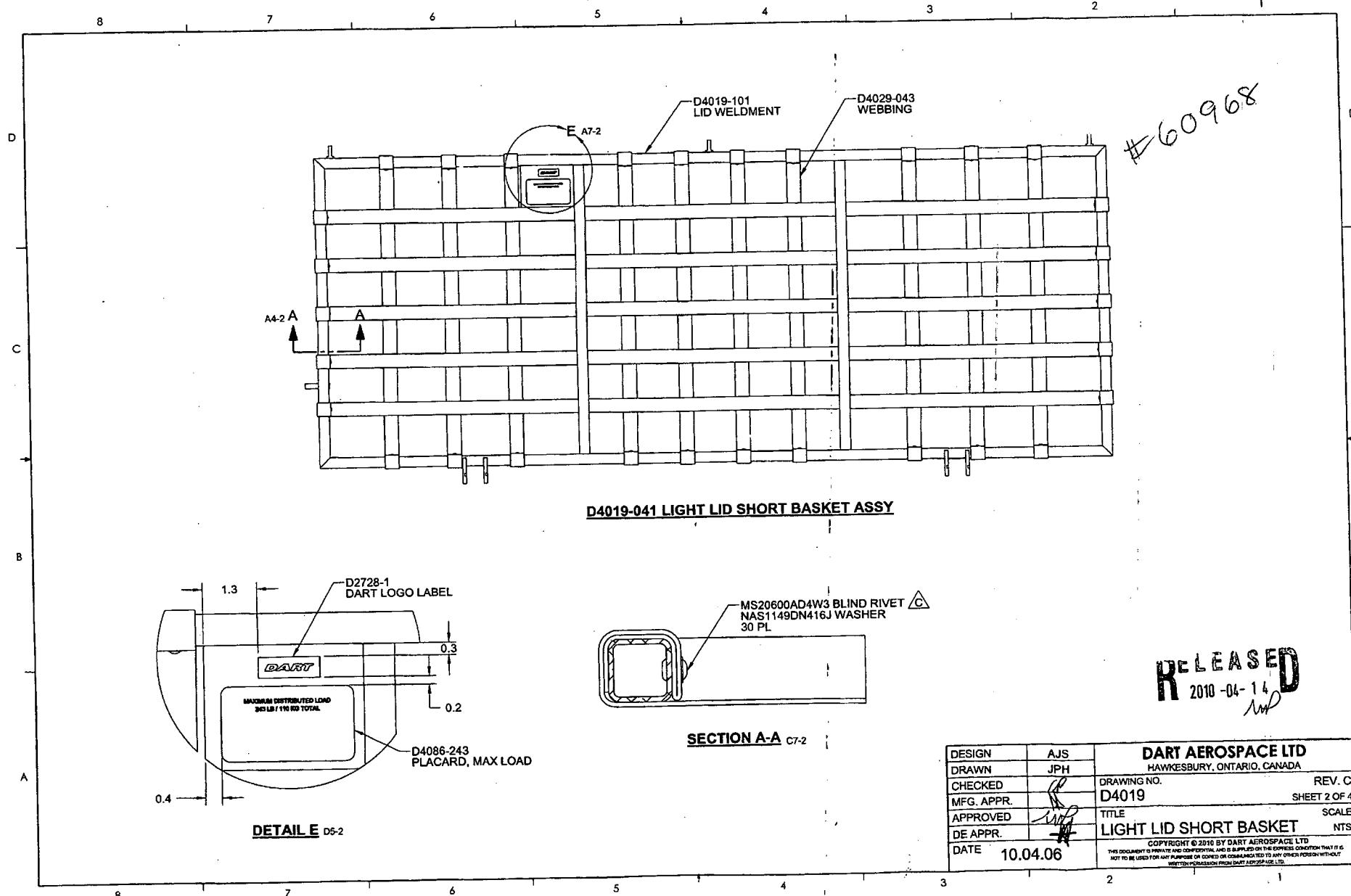
#60968

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



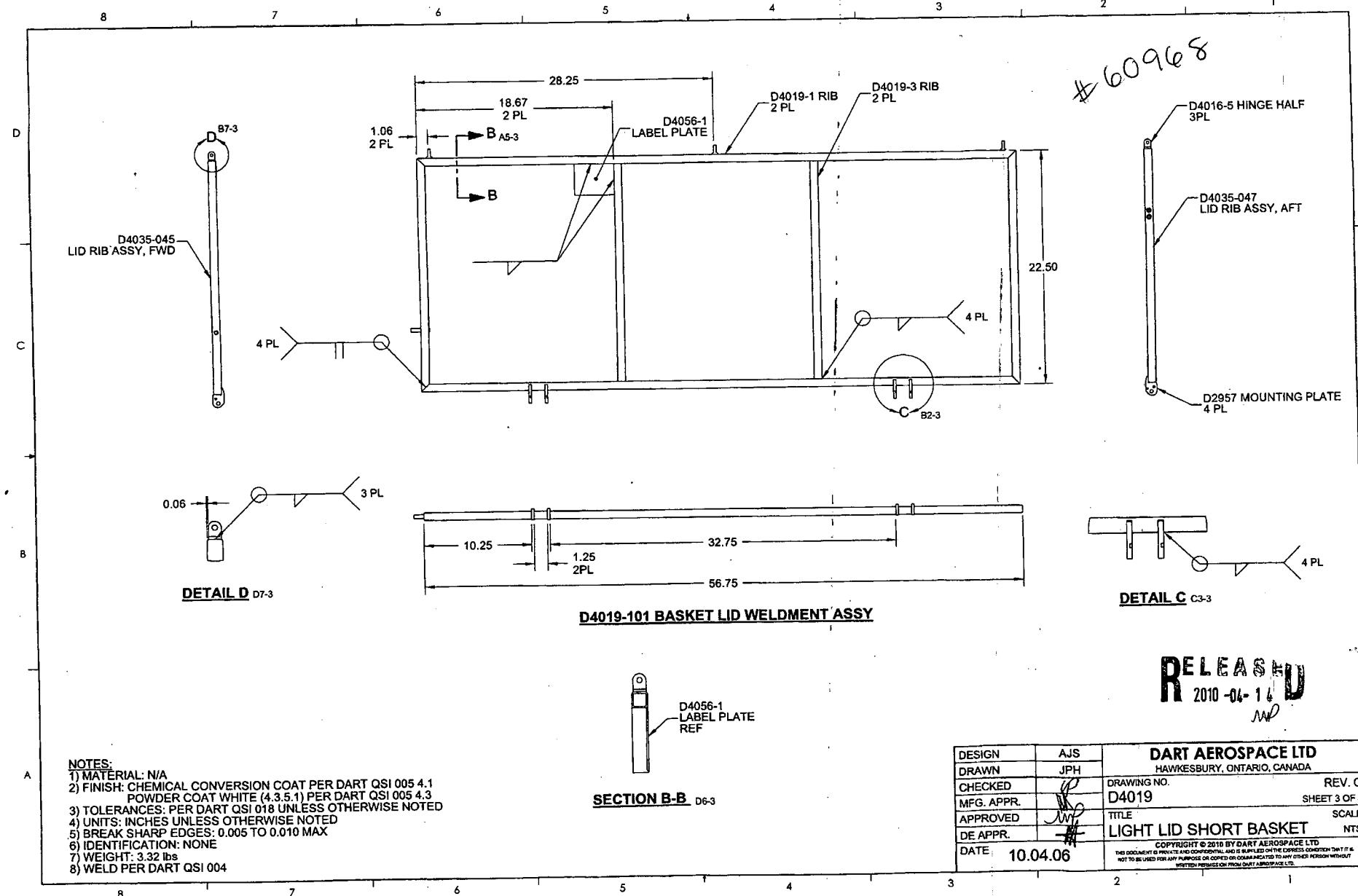
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

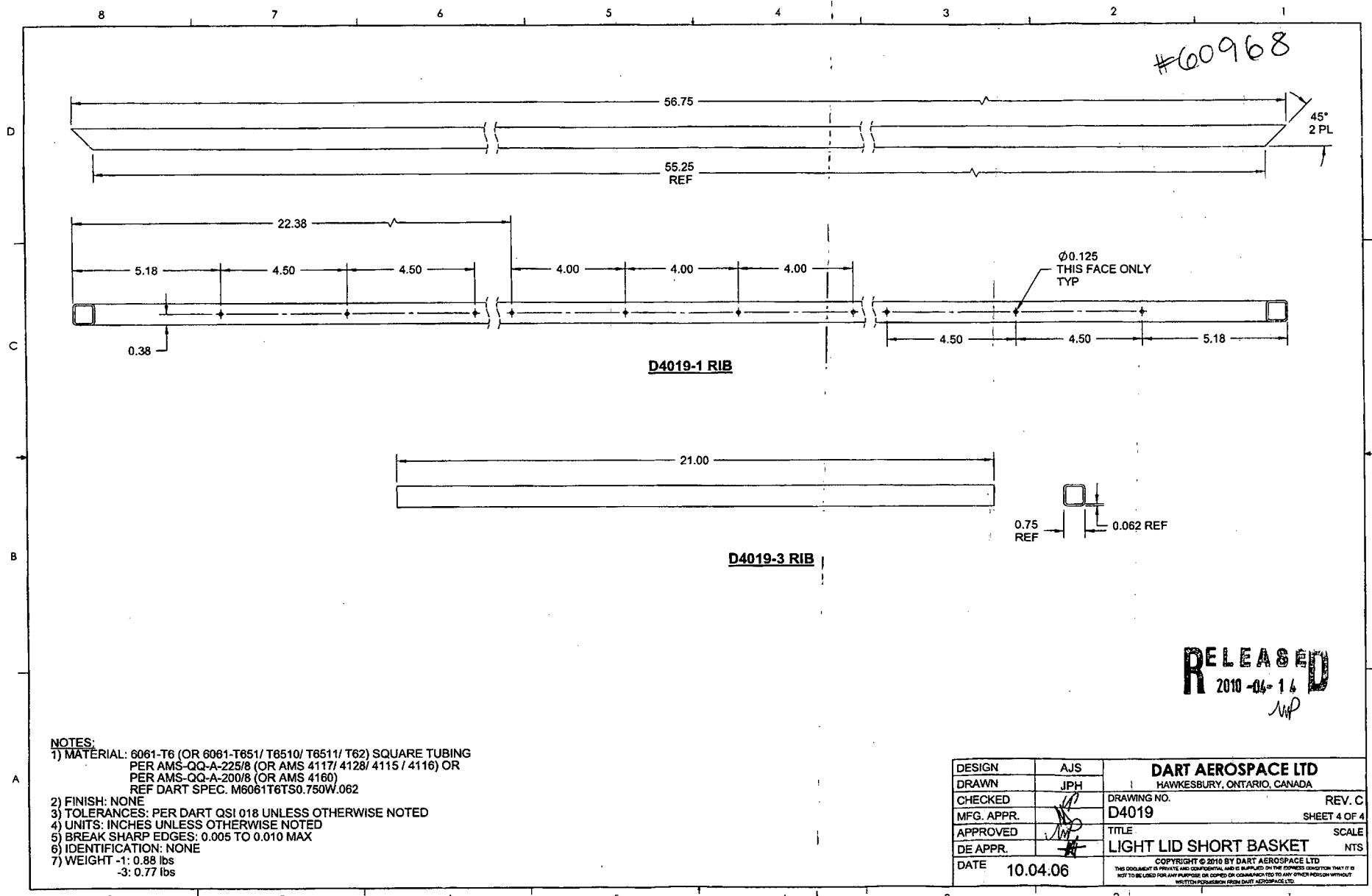


W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D4019	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LIGHT LID SHORT BASKET	
DATE	10.04.06	NTS	

COPYRIGHT © 2010 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED TO ANY OTHER PERSON OR COMPANY
WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD

RELEASED
2010-04-14
[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries